

REPLACEMENT ABSTRACT

In a cold rolling method for producing annular composite workpieces, at least two hollow cylindrical workpieces made of different materials are inserted into one another. The at least two hollow cylindrical workpieces are roll formed by pressing the at least two hollow cylindrical workpieces against each other between two diametrically opposed external roll forming tools and an internal rolling arbor or between two diametrically opposed external roll forming tools and an internal roll forming tool to form a composite workpiece. The composite workpiece is a bearing ring or a gear ring. One of the hollow cylindrical workpieces can be a nonferrous material such as aluminum.